

## CLAIMS

1. A method of creasing a packaging laminate manufactured from cellulose fibres, which packaging laminate comprises a bulk promoting layer (1), here denoted bulk layer, which consists of a network structure of cellulose fibres, and on at least one side of the bulk layer at least one side layer (2b), the side layer and bulk layer being directly or indirectly joined to each other over essentially their entire surfaces facing each other, characterised in that a stamping device is pressed down, in a first side of the laminate, for the formation of a crease line (4), while, on the other side of the laminate, which is opposite to said first side, a holding-on tool is used, which holding-on tool is essentially planar in an area corresponding to the location of the stamping device.
2. A method of creasing according to claim 1, characterised in that the side layer(s) (2b) is/are arranged on said first side of the laminate, whereby said side layer (2b) is brought to sink down into the bulk layer in the crease line, and whereby the laminate is kept essentially planar on the opposite side of the sunk down side layer(s) (2b), in the area of the crease line (4).
3. A method of creasing according to claim 1 or 2, characterised in that said bulk layer (1), is brought to exhibit a compressed structure (5) in the area of the crease line (4), which facilitates folding in the crease line (4) essentially without the formation of bulges or delamination occurring in between the layers or cracks being formed in connection with the crease line (4) in one or two outermost layers (2b, 3) of the laminate.
4. A method of creasing according to any of the preceding claims, characterised in that the bulk layer (1) to 40-95 % consists of cellulose fibres with a freeness of 550-950 ml CSF, that the side layer(s) (2b) has/have a greater density than the bulk layer, and that the laminate has a bending stiffness index greater than  $2.5 \text{ Nm}^7/\text{kg}^3$ , but less than  $14 \text{ Nm}^7/\text{kg}^3$ , calculated as a geometric mean value for machine and

transverse direction.

- 5 5. A method of creasing according to any of the preceding claims, characterised in that at least 60 % of the bulk layer (1) consists of fibres with a freeness value greater than 600 ml CSF, and that the laminate has a bending stiffness index greater than  $3.0 \text{ Nm}^7/\text{kg}^3$ , or more preferred that at least 60 % of the bulk layer (1) consists of fibres with a freeness value greater than 650 ml CSF, most preferred at least 700, but less than 850 ml CSF, the laminate having a bending stiffness index greater than  $4.0 \text{ Nm}^7/\text{kg}^3$ , preferably greater than  $5.0 \text{ Nm}^7/\text{kg}^3$ .
- 10 6. A method of creasing according to any of claims 1-5, characterised in that it is followed by the laminate being folded in the crease line (4), towards said first side of the laminate.
- 15 7. A packaging laminate provided with a crease line, manufactured by a creasing method according to any one of claims 1-6.
- 20 8. A packaging laminate provided with a crease line according to claim 7, characterised in that the laminate is arranged to be folded in the crease line (4), from said first side of the laminate, as well as towards said first side of the laminate.
- 25 9. Packaging produced by the forming by folding of a packaging laminate, which has been creased by to a creasing method according to any one of claims 1-6.
10. Packaging according to claim 9, characterised in that said packaging has been formed by folding by, at least in one crease line (4), folding the laminate towards said first side of the laminate.

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